

**Work Order ID 70913**

Friday, June 17, 2011 7:46:15 AM



Page 1

Item ID: D4008-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Filler Splash Guard Hinge Half

Start Date: 6/17/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-17 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4008

B

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Cut MS20257-3 hinge as per dwg D4008, keep 2nd half for D4008-11

2- Drill holes as per dwg

3- Deburr

  
5/11/06/20 (6)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/06/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 70913

Friday, June 17, 2011 7:46:15 AM



Page 2

Item ID: D4008-5

Accept



Setup Start



Revision ID:

Item Name: Fuel Filler Splash Guard Hinge Half

Stop



Start Date: 6/17/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 6/20/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

Identify as per dwg & Stock Location: 108

0.00



Packaging

Memo

0.00

Packaging

11/6/2011 11/6/2011

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/2011  
ME  
11-06-20

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Friday, June 17, 2011 7:46:21 AM

Page 1  
T

Work Order ID: 70913



Parent Item: D4008-5



Parent Item Name: Fuel Filler Splash Guard Hinge Half

Start Date: 6/17/2011

Required Date: 6/20/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP rev A 10.02.01 new issue Prelim EC verified by: DD IPP Rev:B  
10.05.03 as per ECN10-562 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20257-3-7200

Purchased

No

100

f

49.0188

0.377

1.885



Piano Hinge

ES 11/06/20

Location

Loc Qty

Loc Code

ST449

0.00778948

116817

0.00778948

ST489A

49.011

117543

49.011

1.885

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

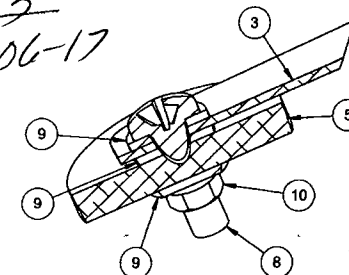
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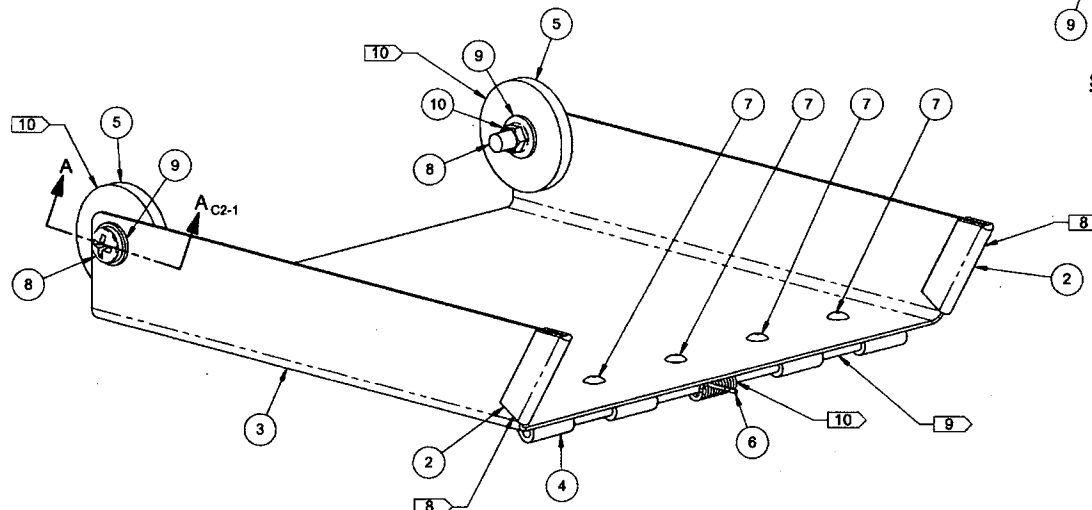
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70913  
PL 11-06-17



SECTION A-A  
SCALE: 2X  
B6-1  
TYP



**D4008-041 AUX TANK FILLER SPLASH GUARD ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.15 lbs
- 8) ATTACH D3941-1 RUBBER CUSHION USING SILICONE ADHESIVE, TRIM TO FIT, AFTER POWDER COAT
- 9) MASK HINGE PIN AREA BEFORE POWDER COAT
- 10) INSTALL D4008-7 WASHER AND D4008-9 SPRING AFTER POWDER COAT

B	ADD ALTERNATE RIVETS FOR -043, ZN D7-2	HS	10.11.03
A	NEW ISSUE	HS	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.03		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D4008		REV. B SHEET 1 OF 10	
TITLE SPLASH GUARD		SCALE NTS	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

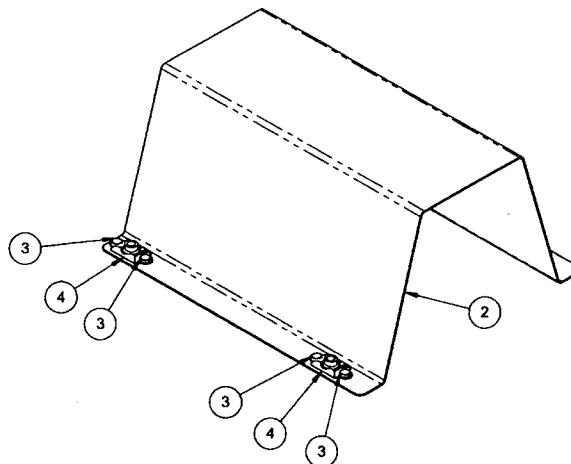
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM NO.	QTY. .043	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4008-043	FUEL PUMP SPLASH GUARD ASSEMBLY	JCA-M47-2-29
2	1	D4008-3	FUEL PUMP SPLASH GUARD COVER	
3	8	MS20472M3-3	RIVET	B
4	4	MS21060L3	ANCHOR NUT	B



**D4008-043 FUEL PUMP SPLASH GUARD ASSEMBLY**

**NOTES:**

- 1) MATERIAL:
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 0.46 lbs

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D4008 SHEET 2 OF 10
APPROVED		TITLE SCALE
DE APPR.		SPLASH GUARD NTS
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**RELEASED**  
2011-05-30  
JW

u670913

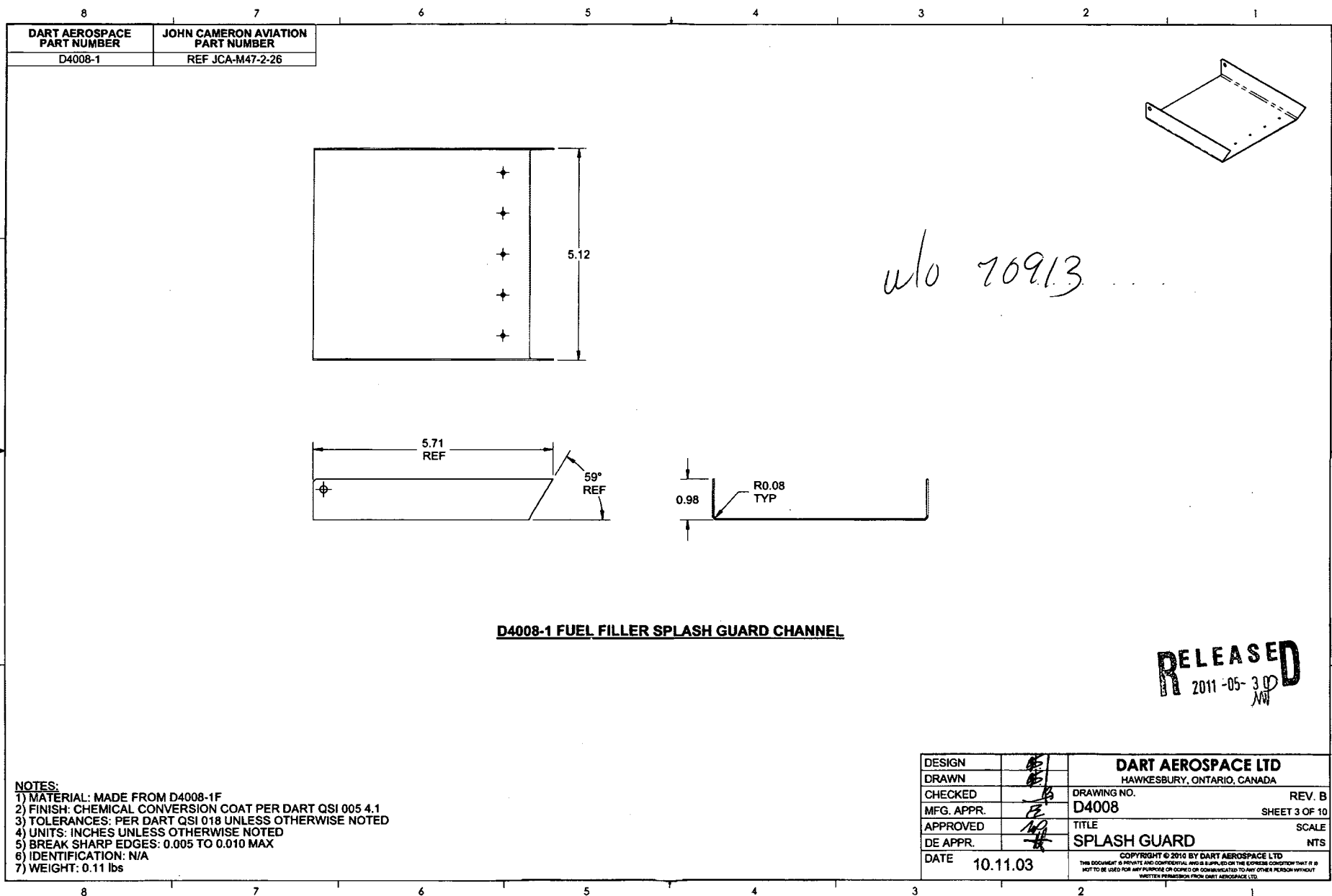
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**NOTES:**

- 1) MATERIAL: MADE FROM D4008-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

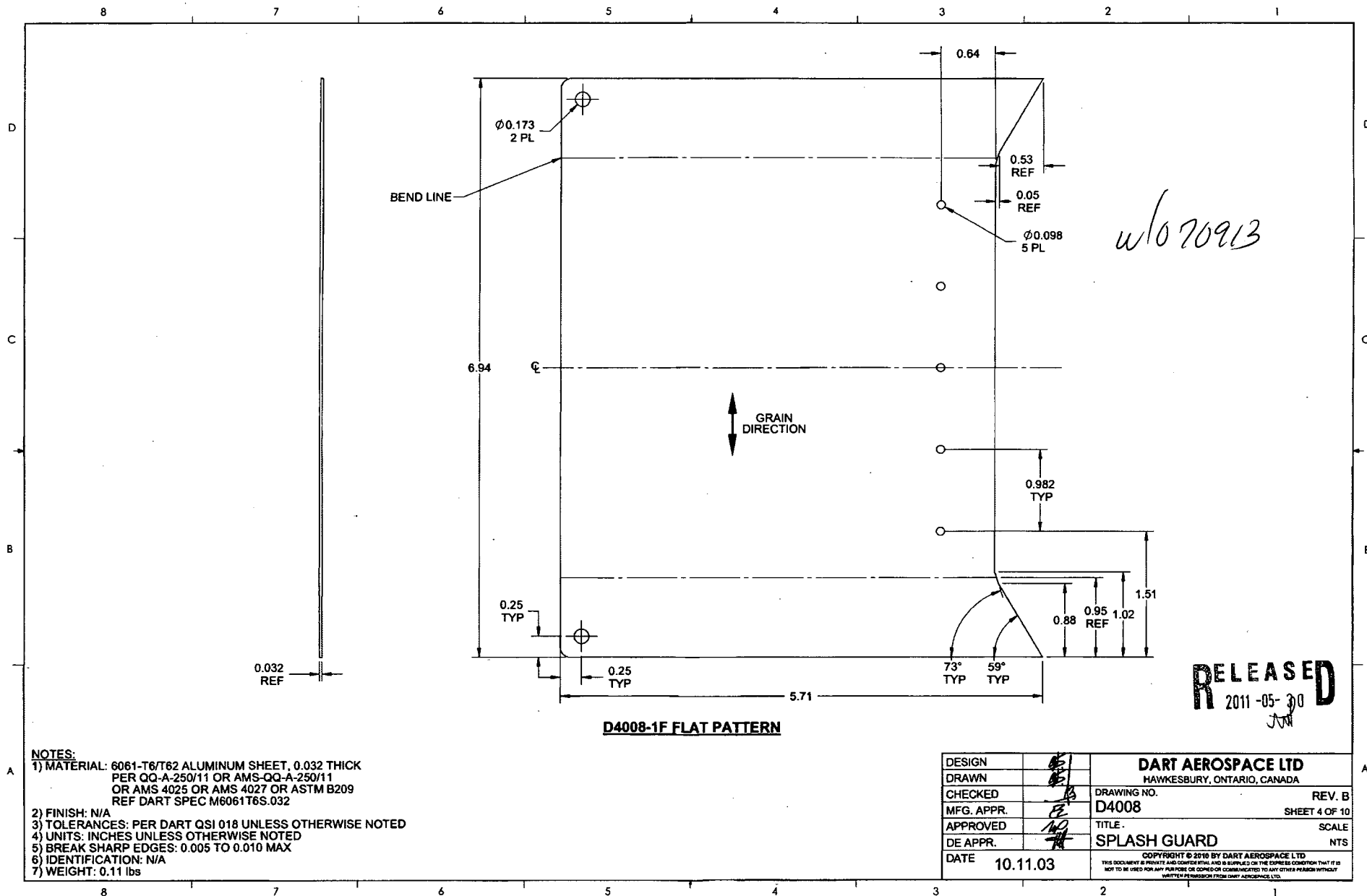
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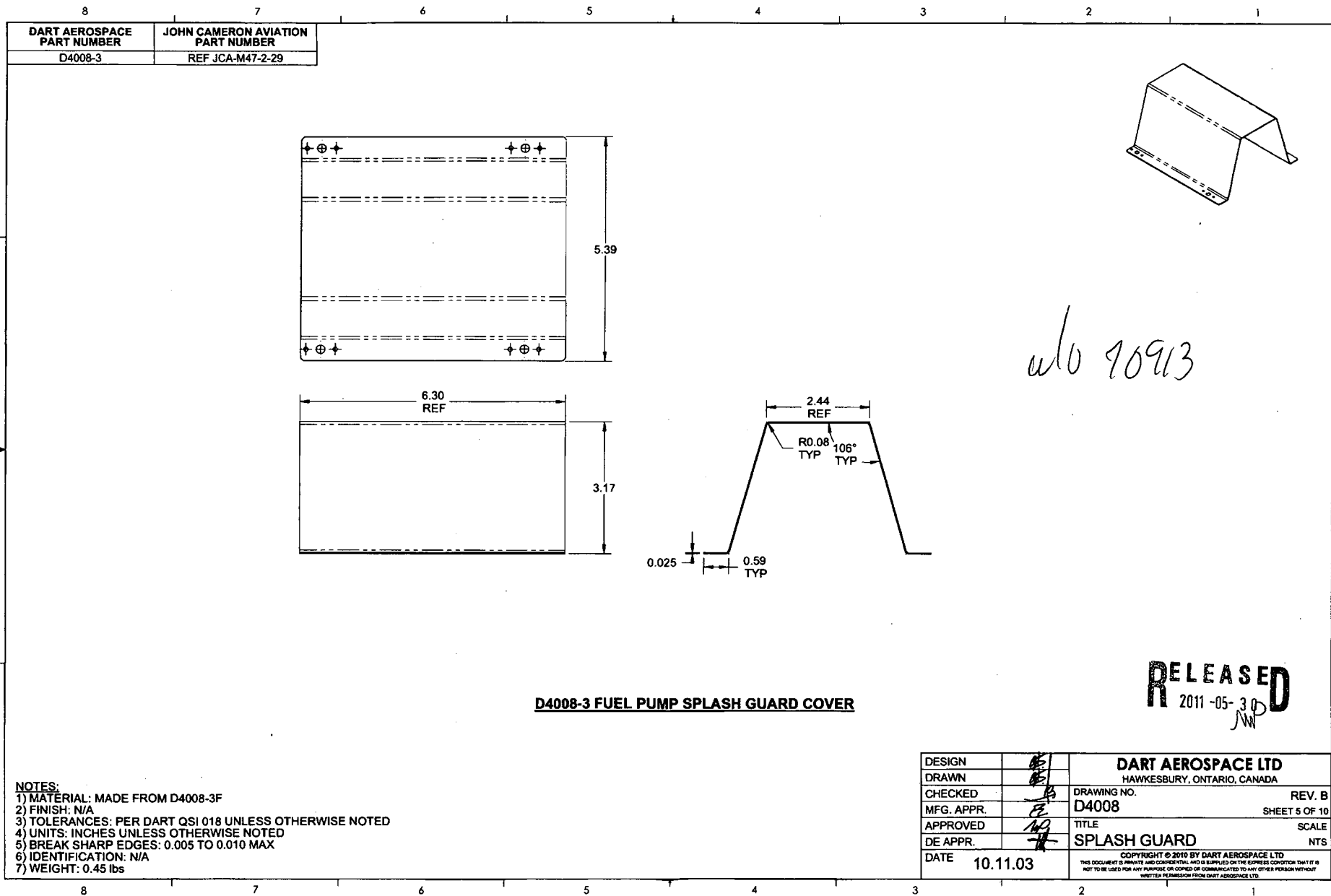
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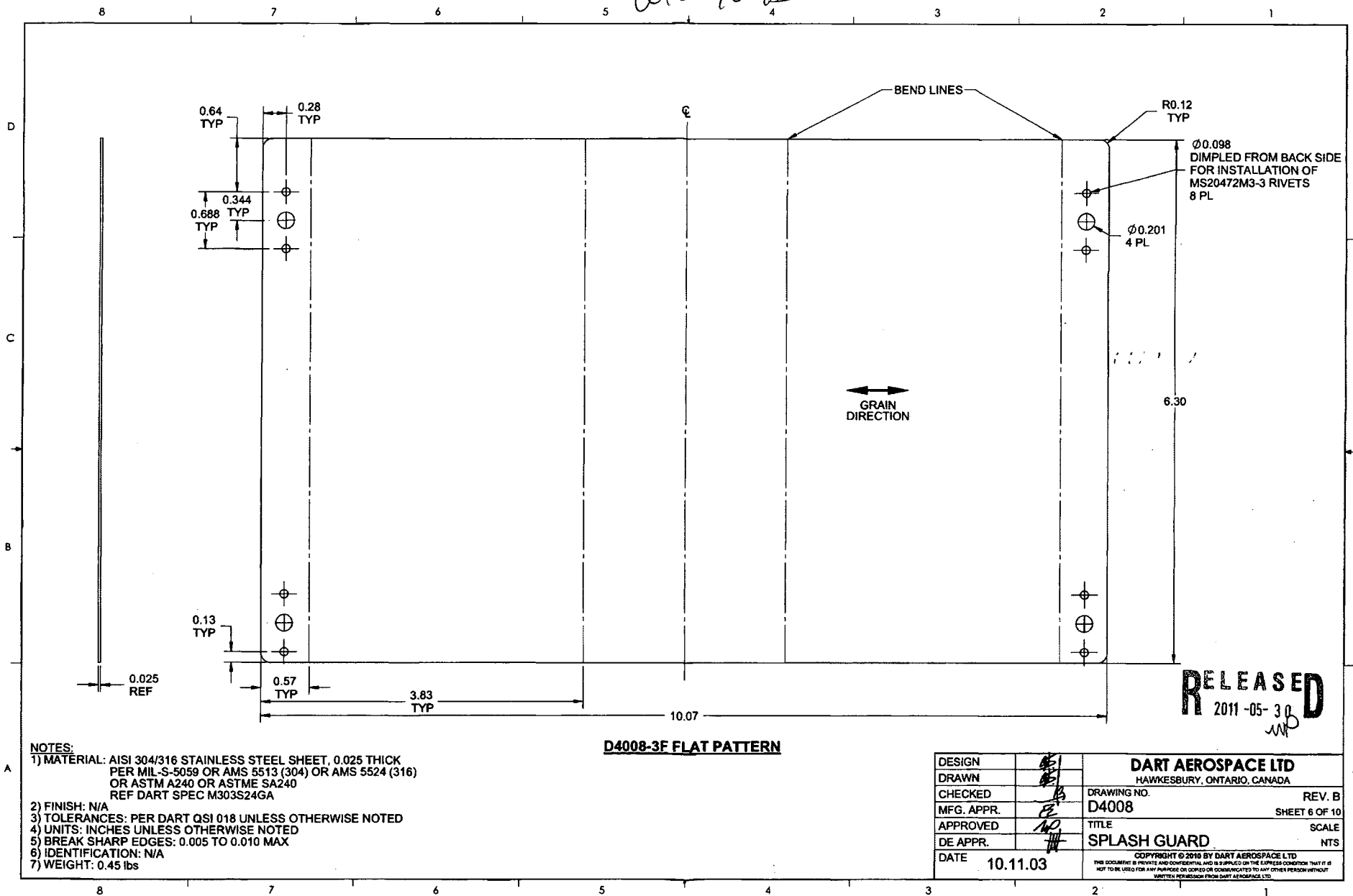
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610 90913



W/O:		WORK ORDER CHANGES					
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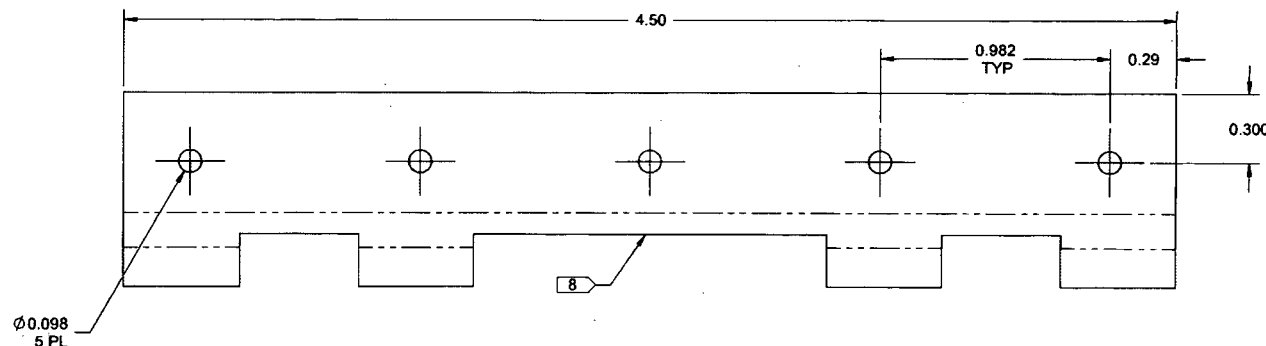
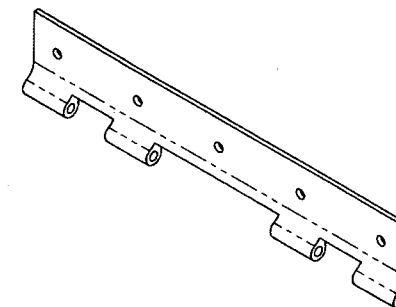
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4008-5	REF JCA-M47-2-26

WLO 70913



**D4008-5 HINGE HALF**

**RELEASED**  
2011-05-30  
JMB

- NOTES:**
- 1) MATERIAL: MADE FROM MS20001-4 HINGE OR MS20257-3 HINGE
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.02 lbs
  - 8) REMOVE CENTER LUG FROM THIS AREA, FLUSH WITH THIS EDGE

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4008</b>	REV. B
MFG. APPR.	<i>[Signature]</i>		SHEET 7 OF 10
APPROVED	<i>[Signature]</i>	TITLE <b>SPLASH GUARD</b>	SCALE
DE APPR.	<i>[Signature]</i>		NTS
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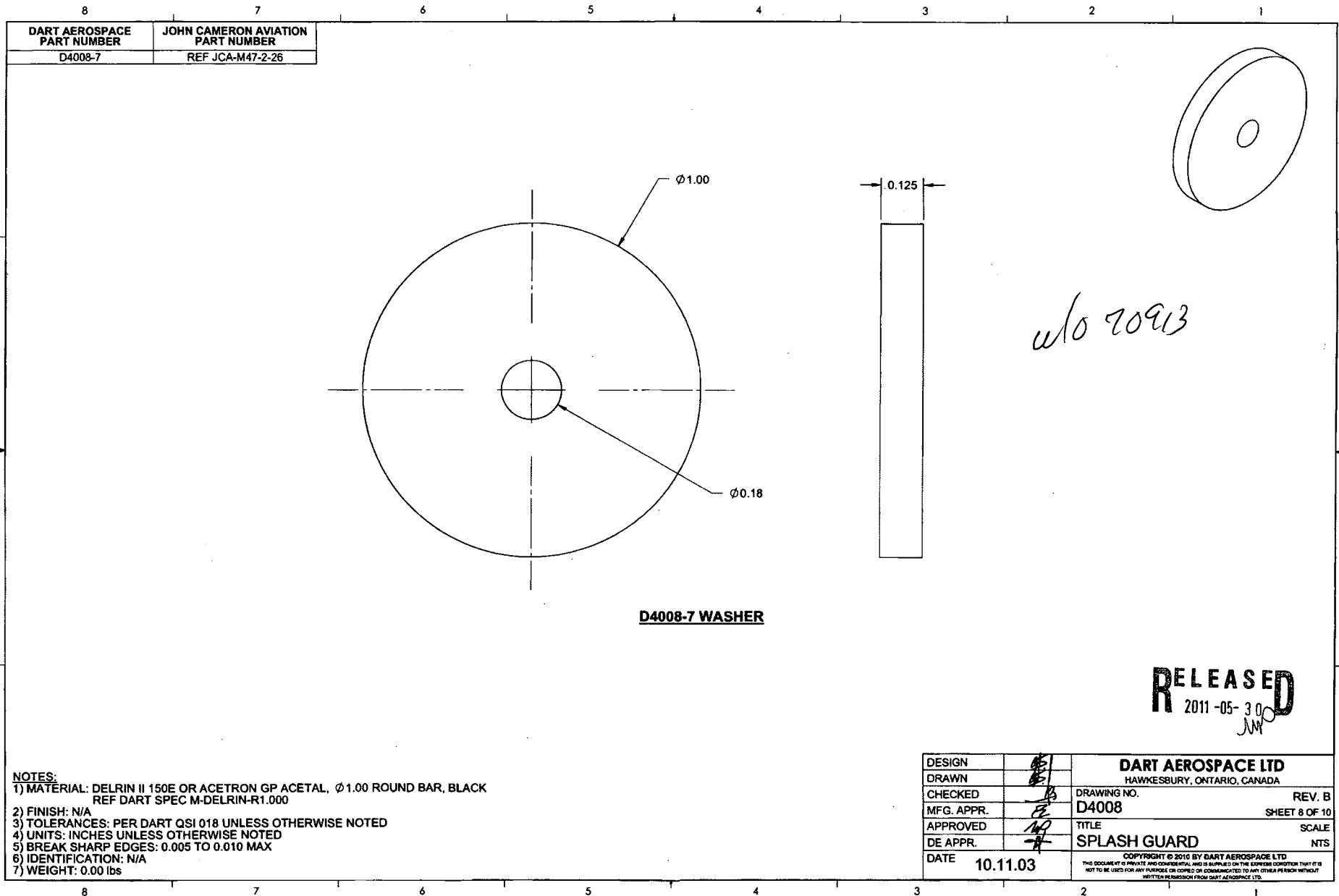
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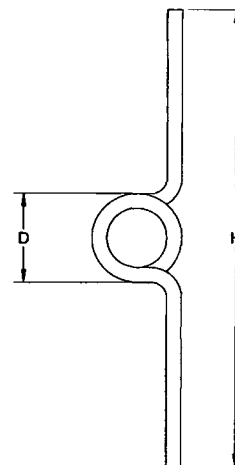
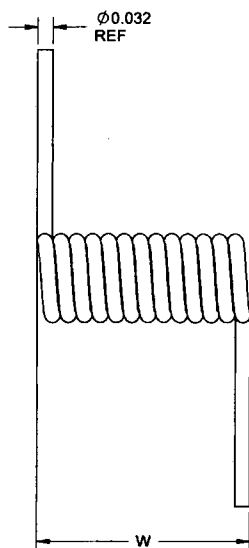
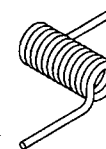
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DART AEROSPACE  
PART NUMBER  
D4008-9

JOHN CAMERON AVIATION  
PART NUMBER  
REF JCA-M47-2-26

## SPECIFICATION CONTROL DRAWING



W/O 20913








DART P/N	SUPPLIER	SUPPLIER P/N	WIDTH "W"	HEIGHT "H"	DIAMETER "D"	MATERIAL
D4008-9	VICTORY SPRING	N/A	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE
D4008-9	BELL HELICOPTER	206-031-140-001	0.46	0.99	0.19	STAINLESS STEEL SPRING WIRE

### D4008-X SPRING

RELEASED  
2011-05-30

#### NOTES:

- 1) MATERIAL: T301 OR 304 STAINLESS STEEL SPRING WIRE  $\phi 0.032$  PER ASTM A313
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. 
MFG. APPR.		<b>D4008</b>	SHEET 9 OF 10
APPROVED		TITLE	SCALE
DE APPR.		<b>SPLASH GUARD</b>	NTS
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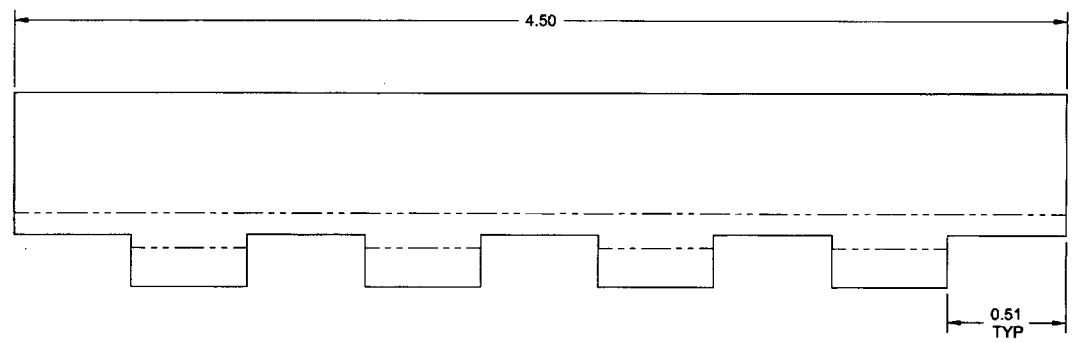
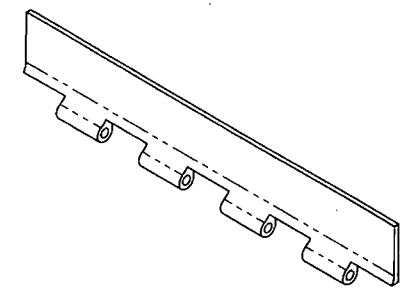
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**NOTE:** Date & initial all entries



also 70913



**D4008-11 TANK HINGE HALF**

**RELEASED**  
2011-05-30  
JW

- NOTES:**
- 1) MATERIAL: MADE FROM MS20001-4 HINGE OR MS20257-3 HINGE
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: STOCK AS D4008-11
  - 7) WEIGHT: 0.01 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4008</b>	SHEET 10 OF 10
APPROVED		TITLE	SCALE
DE APPR.		<b>SPLASH GUARD</b>	NTS
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